

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012630**Date Inspected:** 12-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** William Norris**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girders (OBG)**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

1) OBG Lift 2W repairs

1) The QAI arrived at the ABF facilities at Pier 7 to observed repairs of components on OBG L2W. The QAI observed ABF personnel repairing a damaged section of the OBG Lift 2W. The QAI noted that the original plate has been cut out and the replacement plate being spliced into longitudinal connection plate, line W3, panel point 13. The QAI also noted that the 18.5mm thick, 675mm tall x 530mm wide replacement plate is cut, beveled and appears to be conforming to the repair procedure specification (ABF weld repair report #201002-001, dated 2-15-2010). The QAI noted that the Quality Control (QC) Inspector William Norris is monitoring the welding in progress. The QAI was informed that shielded metal arc welding (SMAW) with 1/8" E7018 electrodes will be used with Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A-1 for the fillet welds and ABF-WPS-D15-1010 for the complete joint penetration (CJP) splice welds. The QAI noted that Al McDaniel, ID 2690, is making the repair welds. The QAI made random observations of welding parameters and preheat temperature which were noted as 110 DC amps and a minimum temperature of 70°F. The QAI noted that the work in progress appeared to be generally conforming to the contract and repair specifications. At approximately 1100 hours, the QAI was informed that welding will be put on hold until further notice. The QAI observed that inclement weather (rain) has started and the area being welded may get wet. The QAI was informed that welding will stop to prevent quenching of the repair welds. The QAI agreed that if ABF could not prevent rain from

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

entering the work / welding area that welding should not continue at this time.

The QAI reviewed contract related documents including the submitted and approved Welding Quality Control Plan (WQCP) and approved revisions to the WQCP for the remainder of the work shift.

Summary of Conversations:

As noted above, the QAI had conversations with the QC Inspector regarding the repair welding and weather conditions. There were also general conversations regarding the status of the work in progress. The QAI relayed the observations of OBG repair welding QAI Bill Levell. There were no other notable observations or conversations during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi, (916)813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Croff,Scott	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
